

Work Order ID 74563

Monday, October 03, 2011 8:57:04 AM

Page 1

Item ID: D206-667-203

Accept

Revision ID:

Item Name: Crosstube Aft

Start Date: 9/30/2011 Start Qty: 1.00

Required Date: 10/21/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *YLS*Date: *11/10/03* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-667-243

Rev C (DEO)

DSI9565

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-203 CHG004

*Scz 10/13**YLS 12-2-13*

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF

*MO/SW/RM**12/1/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

8,262,101

⑩

Quality Control

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 and drill table DT8577. Locate hole #6 for towers as per QSI 10. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff(Donot engrave on outside of tube)-

10 -Deburr & Inspect for surface damage. Repair damage within limits as per

MO/RM/JW 12/2/11

S RM/MO 12/2/11

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Dwg
D206-667-243

140 Crosstubes Chemical Conversion 0.00



HandFXtube

Memo

Hand Finishing Crosstubes

0.00

150 QC3- Inspect Part Finish 0.00



QC

Memo

Quality Control

0.00

160 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

Quality Control

0.00

MO

12/2/11

Sizeloe

Sizeloe

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2	Memo	0.00							<u>112-02-3</u>
Outsource process - NDT	Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>14083</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								
180 	Packaging	0.00							
Packaging	Memo	0.00							<u>112/430</u>
Packaging	Ensure copy of NDT results attached to work order.								
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							<u>5.24.03</u>
Quality Control	Ensure results are as per Dwg D206-667-243								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 10:00

Finish Time: 10:45

PAINT:

Start Time: 2:45

Finish Time: 3:30

As 12 - 2 - 3

210

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

Serialized

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Crosstubes					AL	12	2	-6
Crosstubes		0.00							
Crosstubes	Memo 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: <u>120072</u> 3- Torque bolts as per dwg 4-Install nut plates as per Dwg D206-667-243.								
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

S 12/02/13

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

12/13/13

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/2/13

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-203

Location: 67EPPP Rev: 3

12/14/13

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/2/15

12-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, October 03, 2011 8:57:12 AM

Page 1

Work Order ID: 74563

Parent Item: D206-667-203

Parent Item Name: Crosstube Aft



Start Date: 9/30/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
 IPP Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC
 IPP Rev:I 08-12-15 add magnobond DD verified by:EC
 IPP Rev J 09.01.06 ECN 08-562 EC verified by:DD IPP REV:K
 11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-667-203TRN

Manufactured

No

B75011

220

Each

2.0000

1

1

JW

12-1-31



Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG

2

73925

1

73926

1

D2873-043

Manufactured

No

220

Each

32.0000

2

2

AG 12-2-6



Nut Plate Assembly

*75010

Location

Loc Qty

Loc Code

LG

12

72644

12

LG052

20

73605

20

D2873-045

Manufactured

No

220

Each

25.0000

2

2

AG 12-2-6



Nut Plate Assembly

*74985

Location

Loc Qty

Loc Code

LG

5

71983

1

72562

4

LG052

20

73529

20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D206-667-203



Parent Item Name: Crosstube Aft

Start Date: 9/30/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2892-1 Manufactured No

220 Each 24.0000 2 2



Support



AS 12-2-6

Location Loc Qty Loc Code

LG 24

72483 14

72585 10

2

D3595-063-450 Manufactured No

220 Each 43.5600 4 4



RUBBER CUSHION



AS 12-2-6

*75597

Location Loc Qty Loc Code

LG 9.76

67353 3

68893 6

70113 0.56

71354 0.2

LG055 33.8

72967 33.8

4

MS20601-AD4W10 Purchased No

220 Each 135.0000 14 14



RIVET



AS 12-2-6

*119386

Location Loc Qty Loc Code

LG051 135

116186 3

117676 2

118464 30

118675 100

6

8

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Start Date: 9/30/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Purchased No

220

Each

46.0000

4

4



Clamp(per MIL-DTL-8783C)

#119545



2

12-2-6

LocationLoc QtyLoc Code

LG050

46

116207

7

117506

1

118186

38

2

AN5-10A

Purchased No

250

Each

174.0000

10

10



Bolt



119547

C

LocationLoc QtyLoc Code

ST337

174

116704

16

117795

49

118191

59

118983

50

AN5-32A

Purchased No

250

Each

183.0000

4

4



Bolt



12/2/13

LocationLoc QtyLoc Code

ST339

75

118628

50

118983

25

118983

ST340

108

117872

58

118422

50

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Shop Packet Print

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Start Qty: 1.00

Required Qty: 1.00

AN5-34A

Purchased

No

250

Each

54.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

54

117794

54

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

18

18



Washer

MS21042L5

Purchased

No

250

Each

2,684.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

1184

116105

5

116548

53

117441

248

117611

82

118179

496

118910

300

ST518

1500

119109

1500

117794

119717

118179

MS 118179

W/O:		WORK ORDER CHANGES					
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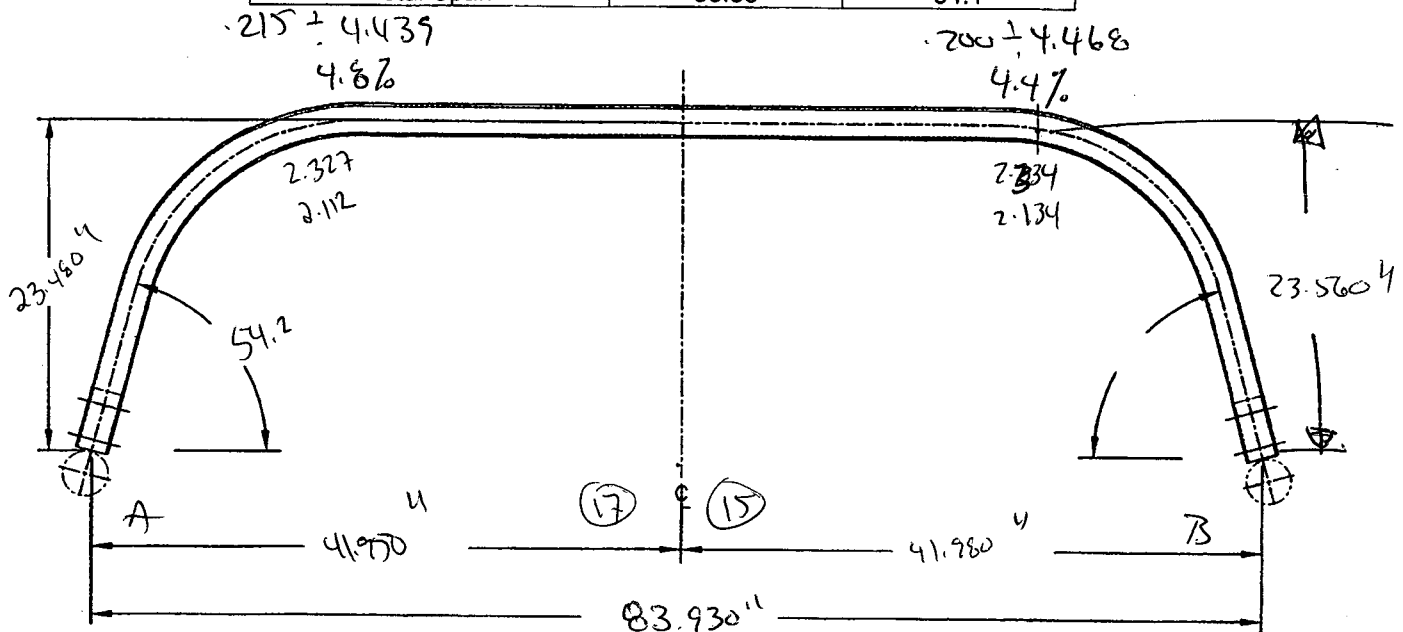
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DART AEROSPACE LTD	Work Order: 74563
Description: Crosstube High Aft (206L)	Part Number: D206-667-203
Inspection Dwg: D206-667-243 Rev: C	Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Comments	
SIDE A2	4.8% crushing @ 17 passes
SIDE B2	4.4% crushing @ 15 passes

QC15 Inspection	δ
Date	12/02/01

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.17	Dwg Rev updated	KJ	
C	09.12.14	Dimensions update per Dwg Rev C	KJ	

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Item	Qty	Part Number	Description
	-243		
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W 10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74563

DEO ATTACHED

ECO #11-615
11.07.28

UNDER REVIEW

RELEASED

C	REVISE GENERAL NOTES/PART LIST (ZN 07-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D8-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

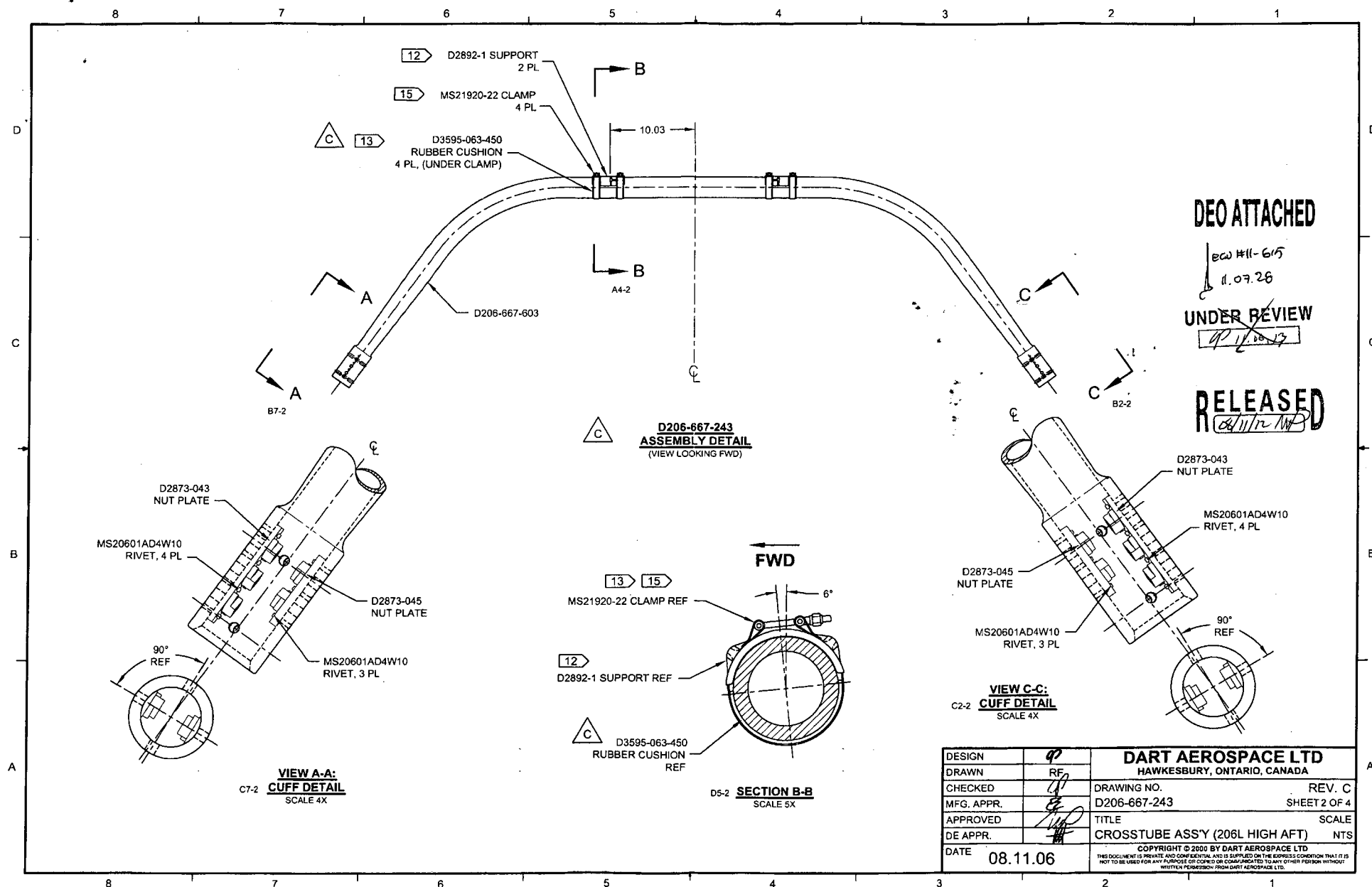
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74563



DEO ATTACHED

800 #11-615
11.07.28

UNDER REVIEW

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

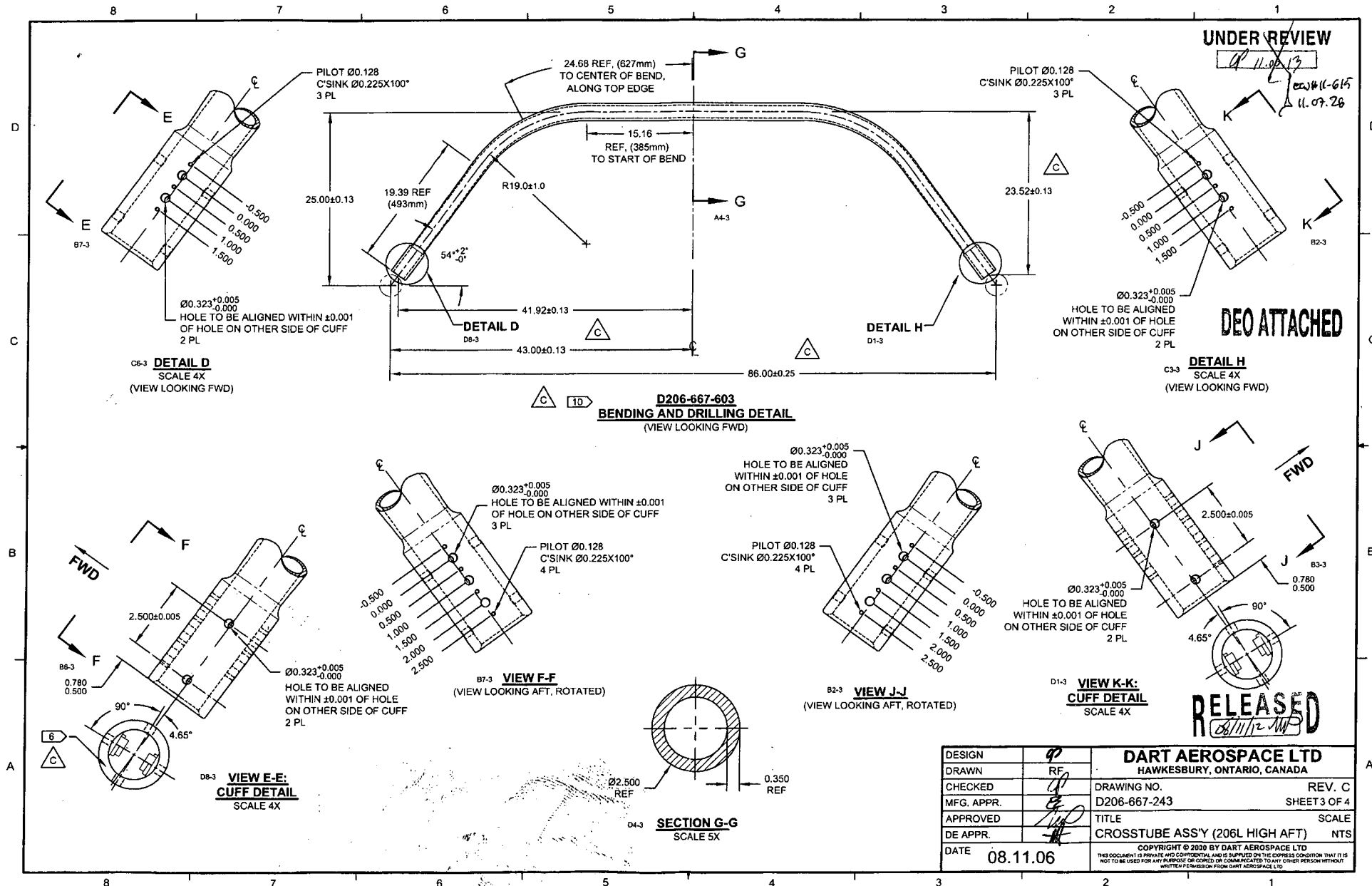
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

11.07.28



RELEASED
8/11/12 M

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>RF</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	D206-667-243	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE 08.11.06		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

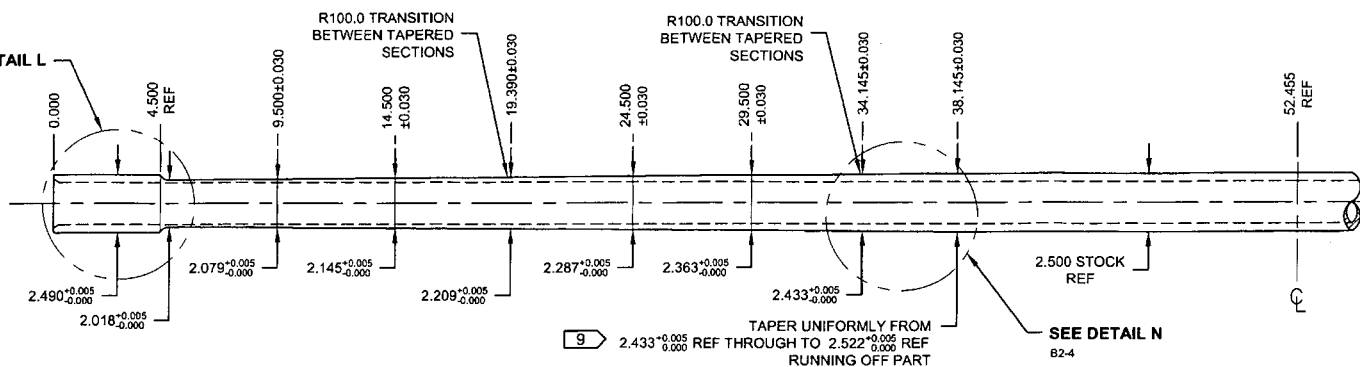
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

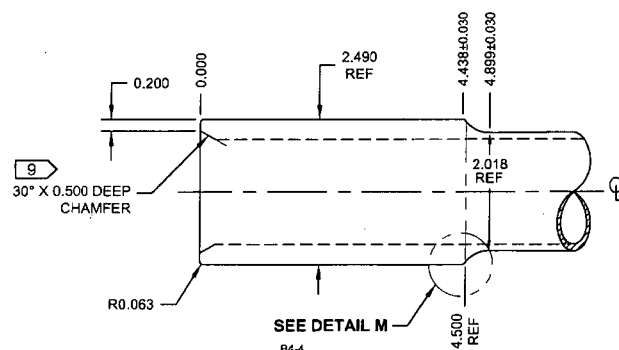
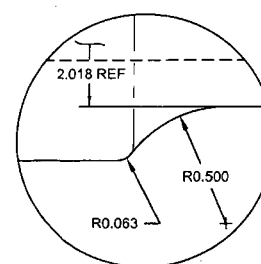
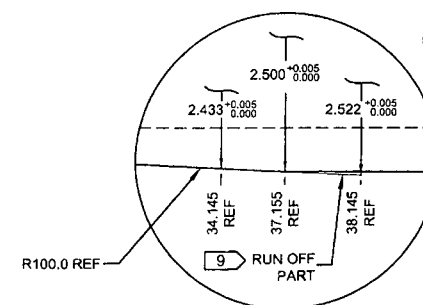
74563

SEE DETAIL L
B7-4
 BCU #11-615
 11.07.28

UNDER REVIEW

DEO ATTACHED

TURNING DETAIL


 C7-4 DETAIL L: CROSSTUBE CUFF
 NOT TO SCALE

 B6-4 DETAIL M:
 CUFF TRANSITION
 NOT TO SCALE

 C4-4 DETAIL N:
 TAPER RUN-OFF
 NOT TO SCALE

RELEASED

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EF	D206-667-243	SHEET 4 OF 4
APPROVED	4P	TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74563

DRAWING NO. D206-667-243	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-243-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN P	CHECKED ASS	MFG. APPR. RB	APPROVED MP	DE APPR. #			
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21			

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:**IS:**

Item	Qty -243	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
Maz

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4		4	AN5-34A	BOLT
21	4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	8	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	10	AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4		4	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	10	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245
ASSEMBLIES ABOVE

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Revision: D
Date: 11.05.01



LIQUID PENETRANT TEST REPORT

P- 14906

CLIENT	<u>Dnt Hewlett</u>	DATE	<u>FEB 3 2012</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA LAUREN</u>	ACUREN JOB No.	<u>1P8-12-C0028</u>	TIME	AM <input checked="" type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	<u>1270 BREIDEN ST.</u> <u>HAWKES BAY N.Z.</u>	PO/WO No.	<u>---</u>	WORK LOCATION	<u>Same</u>		
PROJECT	<u>FPI on</u>	ACCEPTANCE STD	<u>ATA 14701-05</u>	REV./DATE	<u>2005</u>		
ITEM(S) EXAMINED	<u>CROSS TUBES</u>						

JOB DESCRIPTION	PROCEDURE No. <u>LT-002</u> REV./DATE <u>2005</u>	TECHNIQUE No. <u>LT-002</u> REV./DATE <u>2005</u>
PART No.	<u>SEE RESULTS</u>	MATERIAL <u>Aluminum</u> THICKNESS <u>Various</u>
SCOPE	<u>Wet Fluorescent Liquid Penetrant Inspection</u> <u>Carried out 100% External</u>	

TEST DETAILS			
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH
FAMILY BRAND	<u>HISDAFLUX</u>		<input type="checkbox"/> SOLVENT REMOVABLE
PENETRANT	<u>2-0-7</u>	MINIMUM DWELL TIME <u>450</u> MIN.	<input type="checkbox"/> POST EMULSIFIED
PENETRANT REMOVER	<u>4-0-0</u>	MINIMUM DRY TIME <u>>10</u> MIN.	BLACK LIGHT S/N <u>10858</u>
DEVELOPER	<u>1-0-3-2</u>	MINIMUM DWELL TIME <u>10</u> MIN.	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> AMBIENT < 2 fc
	<input type="checkbox"/> DRY		LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT
			<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
			OTHER <u>LAB NO</u>
			LIGHT METER S/N <u>10788 66</u>
			CAL DUE DATE <u>Feb 20 2012</u>

TEST SURFACE			
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input type="checkbox"/> SHOT BLASTED
			<input checked="" type="checkbox"/> CLEAN BARE METAL
			<input type="checkbox"/> > 52°C/125°F

RESULTS-	<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
----------	---

<u>1 cross tube W.O. 78465</u> ✓ <u>1 cross tube W.O. 74564</u> ✓ <u>1 cross tube W.O. 74563</u> ✓ <u>1 cross tube W.O. 79021</u> ✓ <u>1 cross tube W.O. 79020</u> ✓	<u>> 1000 INCHES (1)</u> <u>8/20/10</u>
--	---

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	<u>Andrew Shelton</u>
TECHNICIAN (SIGNATURE):	<u>[Signature]</u>
NAME (PRINT):	<u>Mike [Signature]</u>
CGSB LEVEL	<u>2</u> SNT LEVEL <u>II</u>
CGSB REG. No	<u>6666</u>
CGSB LEVEL	<u>---</u> SNT LEVEL <u>---</u>
CGSB REG. No	<u>---</u>
DTR #	<u>E-63865</u>
REPORT REVIEWED BY:	
NAME	INITIALS